

THAT WHICH IS CLAIMED IS:

1. A process for producing a dilute ethylene stream and a dilute propylene stream from a cracked gas stream, said process comprising the following steps in the order named:

(1) separating said cracked gas stream in a deethanizer zone to produce a C₂ – stream

5 and a C₃+ stream;

(2). hydrogenating said C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream;

(3) separating said C₃+ stream in a depropanizer zone to produce a C₃- stream and a C₄+ stream; and

10 (4) reacting said C₃- stream in a MAPD reactor zone to convert a portion of methylacetylene and propadiene to propylene and propane to produce said dilute propylene stream.

2. A process according to claim 1 further comprising separating said C₄+ stream in a debutanizer zone to produce a C₄ stream and a C₅+ stream.

15 3. A process according to claim 1 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

4. A process according to claim 4 wherein said dilute ethylene derivative unit produces ethylbenzene.

5. A process according to claim 1 further comprising passing said dilute propylene stream
20 to a dilute propylene derivative unit.

6. A process according to claim 5 wherein said dilute propylene derivative unit produces cumene, acrylic acid or propylene oxide.

7 A process according to claim 2 further comprising treating said C_5+ stream in a hydrotreating zone to produce a C_5 diolefins stream, a BTX stream, a DCPD stream and a fuel oil stream.

8. A process according to claim 1 wherein said cracked gas stream is produced by a process
5 comprising:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream; wherein said raw cracked gas stream comprises hydrogen, methane, C_2 hydrocarbons, C_3 hydrocarbons and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a
10 quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized, cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream; and

(5) drying said wet cracked gas stream in a drying zone to form a cracked gas
15 stream.

9. A process according to claim 8 wherein said hydrocarbon feed is selected from the group consisting of ethane, propane, butanes, pentanes, naphtha, and mixtures thereof.

10. A process according to claim 8 wherein said hydrocarbon feed consists essentially of C_5
20 hydrocarbons.

11. A process for producing a dilute ethylene stream and a dilute propylene stream from a cracked gas stream, said process comprising the following steps in the order named:

(1) separating said cracked gas stream in a deethanizer zone to produce a C_2 – stream and a C_3+ stream;

(2) compressing said C₂- stream in a compression zone to form a pressurized C₂- stream;

(3) hydrogenating said pressurized C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream;

5 (4) separating said C₃+ stream in a depropanizer zone to produce a C₃- stream and a C₄+ stream; and

(5) reacting said C₃- stream in a MAPD reactor zone to convert a portion of methylacetylene and propadiene to propylene and propane to produce said dilute propylene stream.

10 12. A process according to claim 11 further comprising separating said C₄+ stream in a debutanizer zone to produce a C₄ stream and a C₅+ stream.

13. A process according to claim 11 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

15 14. A process according to claim 13 wherein said dilute ethylene derivative unit produces ethylbenzene.

15. A process according to claim 11 further comprising passing said dilute propylene stream to a dilute propylene derivative unit.

20 16. A process according to claim 15 wherein said dilute propylene derivative unit produces cumene, acrylic acid, or propylene oxide.

17. A process according to claim 12 further comprising treating C₅+ stream in a hydrotreating zone to produce a C₅ diolefins stream, a BTX stream, a DCPD stream, and a fuel oil stream.

25 18. A process according to claim 11 wherein said cracked gas stream is produced by a process comprising:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream;
 wherein said raw cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃
 hydrocarbons, and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a
 5 quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to
 form a pressurized cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to
 remove a portion of the hydrogen sulfide to form a wet cracked gas stream; and

10 (5) drying said cracked gas stream in a drying zone to produce a cracked gas stream.

19. A process according to claim 18 wherein said hydrocarbon feed is selected from the
 group consisting of ethane, propane, butanes, pentanes, naphtha, and mixtures thereof.

20. A process according to claim 18 wherein said hydrocarbon feed consists essentially of C₅
 hydrocarbons.

15 21. A process for producing a dilute ethylene stream and a dilute propylene stream from a
 cracked gas stream, said process comprising the following steps in the order named:

(1) hydrogenating a portion of the acetylene in said cracked gas stream in a
 hydrogenation zone to produce a reduced acetylene cracked gas stream;

(2) separating said reduced acetylene cracked gas stream in a deethanizer zone to
 20 produce said dilute ethylene stream and a C₃+ stream;

(3) separating said C₃+ stream in said depropanizer zone to produce a C₃- stream and
 a C₄+ stream; and

(4) reacting said C₃- stream in a MAPD reactor zone to convert a portion of
 methylacetylene and propadiene to propylene and propane to produce the dilute propylene
 25 stream.

22. A process according to claim 21 further comprising separating said C₄+ stream in a debutanizer zone to produce a C₄ stream and a C₅+ stream.

23. A process according to claim 21 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

5 24. A process according to claim 21 wherein said dilute ethylene derivative unit produces ethylbenzene.

25. A process according to claim 21 further comprising passing said dilute propylene stream to a dilute propylene derivative unit.

10 26. A process according to claim 25 wherein said dilute propylene derivative unit produces cumene, acrylic acid, or propylene oxide.

27. A process according to claim 22 further comprising treating C₅+ stream in a hydrotreating zone to produce a C₅ diolefins stream, a BTX stream, a DCPD stream, and a fuel oil stream.

15 28. A process according to claim 21 wherein said cracked gas stream is produced by a process comprising:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream; wherein said raw cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃ hydrocarbons, and heavier constituents;

20 (2) quenching said raw cracked gas stream in a quenching zone to produce a quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized, cracked gas stream;

25 (4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream; and

(5) drying said cracked stream in a drying zone to produce a cracked gas stream.

29. A process according to claim 25 wherein said hydrocarbon feed is selected from the group consisting of ethane, propane, butanes, pentanes, naphtha and mixtures thereof.

30. A process according to claim 25 wherein said hydrocarbon feed consists essentially of C₅ hydrocarbons.

31. A process for producing a dilute ethylene stream and a dilute propylene stream, said process comprising the following steps in the order named:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream; wherein said cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃

10 hydrocarbons and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;

15 (4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream;

(5) drying said wet cracked gas stream in a drying zone to produce a cracked gas stream.

20 (6) separating said cracked gas stream in a deethanizer zone to produce a C₂- stream and a C₃+ stream;

(7) compressing said C₂- stream in a second compression zone to form a pressurized C₂- stream;

(8) hydrogenating said pressurized C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream; and

(9) separating said C₃+ stream in a depropanizer zone to produce said dilute propylene stream and a C₄+ stream.

(10) reacting said C₃- stream in a MAPD reactor zone to convert a portion of methylacetylene and propadiene to propylene and propane to produce said dilute propylene stream.

32. A process according to claim 31 further comprising separating said C₄+ stream in a debutanizer zone to produce a C₄ stream and a C₅+ stream.

33. A process according to claim 32 further comprising treating C₅+ stream in a hydrotreating zone to produce a C₅ diolefins stream, a BTX stream, a DCPD stream, and a fuel oil stream.

34. A process according to Claim 31 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

35. A process according to claim 34 wherein said dilute ethylene derivative unit produces ethylbenzene.

36. A process according to claim 31 further comprising passing said dilute propylene stream to a dilute propylene derivative unit.

37. A process according to claim 36 wherein said dilute propylene derivative unit produces cumene, acrylic acid or propylene oxide.

38. A process according to claim 31 wherein said hydrocarbon feed is selected from the group consisting of ethane, propane, butanes, pentanes, naphtha and mixtures thereof.

39. A process according to claim 31 wherein said hydrocarbon feed consists essentially of C₅ hydrocarbons.

40. A process for producing a dilute ethylene stream and a dilute propylene stream, said process comprising the following steps in the order named:

(1) heating a hydrocarbon feed in a cracking zone to form a cracked gas stream; wherein said cracked gas stream comprises hydrogen, methane, C_2 hydrocarbons, C_3 hydrocarbons, and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a
5 quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream;

10 (5) drying said wet cracked gas stream in a drying zone to produce a cracked gas stream;

(6) separating said cracked gas stream in a deethanizer zone to produce a C_2 - stream and a C_3+ stream;

15 (7) hydrogenating said pressurized, C_2 - stream in said hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream; and

(8) separating said C_3+ stream in a depropanizer zone to produce said dilute propylene stream and a C_4+ stream.

20 (9) reacting said C_3 - stream in a MAPD zone to convert a portion of methylacetylene and propadiene to propylene and propane to produce said dilute propylene stream.

41. A process according to claim 40 further comprising separating said C_4+ stream in a debutanizer zone to produce a C_4 stream and a C_5+ stream.

42. A process according to claim 40 further comprising treating C_5+ stream in a hydrotreating zone to produce a C_5 diolefins stream, a BTX stream, a DCPD stream, and a fuel
25 oil stream.

43. A process according to Claim 40 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

44. A process according to Claim 43 wherein said dilute ethylene derivative unit produces ethylbenzene.

5 45. A process according to Claim 40 further comprising passing said dilute propylene stream to a dilute propylene derivative unit.

46. A process according to Claim 45 wherein said dilute propylene derivative unit produces cumene, acrylic acid, or propylene oxide.

10 47. A process according to claim 40 wherein said hydrocarbon feed is selected from the group consisting of ethane, propane, ethane-propane mix, butanes, pentanes and naphtha and mixtures thereof.

48. A process according to claim 40 wherein said hydrocarbon feed consists essentially of C₅ hydrocarbons.

15 49. A process for producing a dilute ethylene stream and a dilute propylene stream from a cracked gas stream, said process comprising the following steps in the order named:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream; wherein said raw cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃ hydrocarbons, and heavier constituents;

20 (2) quenching said raw cracked gas stream in a quenching zone to produce a quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream; and

25 (5) drying said cracked gas stream in a drying zone to produce a cracked gas stream.

(6) hydrogenating a portion of the acetylene in said cracked gas stream in a hydrogenation zone to produce a reduced acetylene cracked gas stream;

(7) separating said reduced acetylene cracked gas stream in a deethanizer zone to produce said dilute ethylene stream and a C₃+ stream;

5 (8) separating said C₃+ stream in said depropanizer zone to produce a C₃- stream and a C₄+ stream; and

(9) reacting said C₃- stream in a MAPD reactor zone to convert a portion of methylacetylene and propadiene to propylene and propane to produce the dilute propylene stream.

10 50. A process according to claim 49 further comprising separating said C₄+ stream in a debutanizer zone to produce a C₄ stream and a C₅+ stream.

51. A process according to claim 49 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

15 52. A process according to claim 51 wherein said dilute ethylene derivative unit produces ethylbenzene.

53. A process according to claim 49 further comprising passing said dilute propylene stream to a dilute propylene derivative unit.

54. A process according to claim 53 wherein said dilute propylene derivative unit produces cumene, propylene oxide, or acrylic acid.

20 55. A process according to claim 50 further comprising treating C₅+ stream in a hydrotreating zone to produce a C₅ diolefins stream, a BTX stream, a DCPD stream, and a fuel oil stream.

56. A process according to claim 49 wherein said hydrocarbon feed is selected from the group consisting of ethane, propane, butanes, pentanes, naphtha and mixtures thereof.

57. A process according to claim 49 wherein said hydrocarbon feed consists essentially of C₅ hydrocarbons.

58. A process for producing a dilute ethylene stream and a dilute propylene stream from a cracked gas stream, said process comprising the following steps in the order named:

5 (1) separating said cracked gas stream in a deethanizer zone to produce a C₂ – stream and a C₃+ stream;

(2). hydrogenating said C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream;

(3) routing said C₃+ stream to storage or other process unit.

10 59. A process according to claim 58 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

60 A process according to claim 59 wherein said dilute ethylene derivative unit produces ethylbenzene.

61. A process for producing a dilute ethylene stream from a cracked gas stream, said process
15 comprising the following steps in the order named:

(1) separating said cracked gas stream in a deethanizer zone to produce a C₂ – stream and a C₃+ stream;

(2) compressing said C₂- stream in a compression zone to form a pressurized C₂- stream;

20 (3) hydrogenating said pressurized C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream;

(4) routing said C₃+ stream to storage or other process unit.

62. A process according to claim 61 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

63. A process according to claim 62 wherein said dilute ethylene derivative unit produces ethylbenzene.

64. A process for producing a dilute ethylene stream from a cracked gas stream, said process comprising the following steps in the order named:

- 5 (1) hydrogenating a portion of the acetylene in said cracked gas stream in a hydrogenation zone to produce a reduced acetylene cracked gas stream;
- (2) separating said reduced acetylene cracked gas stream in a deethanizer zone to produce said dilute ethylene stream and a C₃+ stream;
- (3) routing said C₃+ stream to storage or other process unit.

10 65. A process according to claim 64 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

66. A process according to claim 65 wherein said dilute ethylene derivative unit produces ethylbenzene.

15 67. A process for producing a dilute ethylene stream said process comprising the following steps in the order named:

- (1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream; wherein said cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃ hydrocarbons and heavier constituents;
- 20 (2) quenching said raw cracked gas stream in a quenching zone to produce a quenched, cracked gas stream;
- (3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;
- (4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream;

(5) drying said wet cracked gas stream in a drying zone to produce a cracked gas stream.

(6) separating said cracked gas stream in a deethanizer zone to produce a C₂- stream and a C₃+ stream;

5 (7) compressing said C₂- stream in a second compression zone to form a pressurized C₂- stream;

(8) hydrogenating said pressurized C₂- stream in a hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream; and

(9) routing said C₃+ stream to storage or other process unit.

10 68. A process according to claim 67 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

69. A process according to claim 68 wherein said dilute ethylene derivative unit produces ethylbenzene.

70. A process for producing a dilute ethylene stream, said process comprising the following
15 steps in the order named:

(1) heating a hydrocarbon feed in a cracking zone to form a cracked gas stream;
wherein said cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃ hydrocarbons, and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a
20 quenched, cracked gas stream;

(3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream;

(5) drying said wet cracked gas stream in a drying zone to produce a cracked gas stream;

(6) separating said cracked gas stream in a deethanizer zone to produce a C₂- stream and a C₃+ stream;

5 (7) hydrogenating said pressurized, C₂- stream in said hydrogenation zone to remove a portion of the acetylene to produce said dilute ethylene stream; and

(8) routing said C₃+ stream to storage or other process unit.

71. A process according to claim 70 further comprising passing said dilute ethylene stream to a dilute ethylene derivative unit.

10 72. A process according to claim 70 wherein said dilute ethylene derivative unit produces ethylbenzene.

73. A process for producing a dilute ethylene stream, said process comprising the following steps in the order named:

(1) heating a hydrocarbon feed in a cracking zone to form a raw cracked gas stream;

15 wherein said raw cracked gas stream comprises hydrogen, methane, C₂ hydrocarbons, C₃ hydrocarbons, and heavier constituents;

(2) quenching said raw cracked gas stream in a quenching zone to produce a quenched, cracked gas stream;

20 (3) compressing said quenched, cracked gas stream in a first compression zone to form a pressurized cracked gas stream;

(4) deacidifying said pressurized, cracked gas stream in a deacidifying zone to remove a portion of the hydrogen sulfide to form a wet cracked gas stream; and

(5) drying said cracked gas stream in a drying zone to produce a cracked gas stream.

(6) hydrogenating a portion of the acetylene in said cracked gas stream in a
25 hydrogenation zone to produce a reduced acetylene cracked gas stream;

(7) separating said reduced acetylene cracked gas stream in a deethanizer zone to produce said dilute ethylene stream and a C_3+ stream;

(8) routing said C_3+ stream to storage or other process unit.

74. A process according to claim 73 further comprising passing said dilute ethylene stream
5 to a dilute ethylene derivative unit.

75. A process according to claim 73 wherein said dilute ethylene derivative unit produces ethylbenzene.